

Work Order ID 74711

Wednesday, October 05, 2011 12:56:44 PM



Page 1

Item ID: D350-567-115

Accept



Setup Start



Revision ID:

Stop



Item Name: Interior Floor Window

Start Date: 10/5/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 10/14/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan: MLJDate: 11/10/05

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D350-567	Rev D								
100		0.00							
	DOCUMENT CONTROL								
DC	Memo	0.00							
Document Control	Photocopy bluefile and create labels per PPP D350-567-115 CHG004								
110	Pick Kit	0.00							
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
QC	Memo	0.00							
Quality Control									

Suklo/zo

JG for MLI 11-10-6

(4)

SP 11-10-11

Suklo/zo

(4)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D350-567-115								
	Location: <u>22</u>								
	PPP Rev: <u>30</u>								
140		0.00							
	QC21- Final Inspection - Work Order Release								
QC	Memo	0.00							
Quality Control									

11/10/21 SF (4)

R11-10-24 (H)

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W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Parent Item: D350-567-115




Parent Item Name: Interior Floor Window

Start Date: 10/5/2011**Required Date:** 10/14/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 04-08-24 JLM
IPP Rev:B CHG#2 ECN 1055 07-11-21 DD verified by:EC
IPP Rev:C 08-10-07 as per revD DD verified by:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN526C632R12 		Purchased	No			110	Each	23.0000	9	36			
Screw													
				<u>Location</u>				<u>Loc Qty</u>					
				ST326				23					
					118368			23					
D2463 		Manufactured	No			110	f	638.5388	4.41	17.64			
Seal													
				<u>Location</u>				<u>Loc Qty</u>					
				ST404				638.5388					
					64944			1.71					
					66954			136.8288					
					72232			500					
1X (d2463-0530 AS PER DWG) CUT TO 53.00"													
D3293-1 		Manufactured	No			110	Each	8.0000	1	4			
Doubler													
				<u>Location</u>				<u>Loc Qty</u>					
				ST211				8					
					73750			8					

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Work Order ID: 74711

Parent Item: D350-567-115

Parent Item Name: Interior Floor Window

Start Date: 10/5/2011

Required Date: 10/14/2011

Start Qty: 4.00

Required Qty: 4.00

D3294-1 Manufactured No 110 Each 14.0000 1 4

Bracket

Location	Loc Qty	Loc Code
ST212	14	
69340	1	
73452	5	
73722	8	

D3295-041 Manufactured No 110 Each 0.0000 1

Floor Window

D3296-041 Manufactured No 110 Each 0.0000 1

Door Assembly

MS20470AD4-5 Purchased No 110 Each 2,382.000 2

Rivet, Universal Head

Location	Loc Qty	Loc Code
ST319	2382	
118405	2382	

MS20470AD4-6 Purchased No 110 Each 2,933.000 115

Rivet, Universal Head

Location	Loc Qty	Loc Code
ST319	1933	
117395	32	
117887	386	
118927	1515	
ST320	1000	
119109	1000	

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Parent Item Name: Interior Floor Window

Start Date: 10/5/2011

Required Date: 10/14/2011

Start Qty: 4.00

Required Qty: 4.00

MS20470AD4-7

Purchased

No

110

Each

2,244.000

15

60



Rivet, Universal Head

Location

Loc Qty

Loc Code

ST320

2244

116081

117

117887

839

118614

1288

110

Each

212.0000

9

36

MS21042L06

Purchased

No



Nut

Location

Loc Qty

Loc Code

ST300

212

118354

12

118686

100

119109

100

110

Each

831.0000

9

36

NAS1149DN632J

Purchased

No



Washer

Location

Loc Qty

Loc Code

ST297

831

118428

831

SP

60x

~~11/7/677/30x~~
SP 11-10-11

27x118686

SP 11-10-11

36x

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W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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REFERENCE ONLY

5.0 PARTS LIST

Qty -015	Qty -017	Qty -025	Qty -027	Qty -111	Qty -117	Part Number	Description
X						D350-567-015	FLOOR WINDOW INSTALLATION (SMALL)
	X					D350-567-017	FLOOR WINDOW INSTALLATION (SMALL)
		X				D350-567-025	FLOOR WINDOW INSTALLATION (LARGE)
			X			D350-567-027	FLOOR WINDOW INSTALLATION (LARGE)
				X		D350-567-111	FLOOR WINDOW INSTALLATION (EXTRA LARGE)
					X	D350-567-117	FLOOR WINDOW INSTALLATION (EXTRA LARGE)
1	1					D350-567-013	REPLACEMENT WINDOW KIT (SMALL)
		1	1			D350-567-023	REPLACEMENT WINDOW KIT (LARGE)
				1	1	D350-567-113	REPLACEMENT WINDOW KIT (EXTRA LARGE)
	1		1	1		D350-567-115	INTERIOR FLOOR WINDOW KIT
1		1			1	D350-567-031	INTERIOR FLOOR WINDOW KIT (SLIDING DOOR COMPATABLE)

Qty -013	Qty -023	Qty -113	Qty -115	Qty -031	Part Number	Description
X					D350-567-013	REPLACEMENT WINDOW KIT (SMALL)
	X				D350-567-023	REPLACEMENT WINDOW KIT (LARGE)
		X			D350-567-113	REPLACEMENT WINDOW KIT (EXTRA LARGE)
			X		D350-567-115	INTERIOR FLOOR WINDOW KIT
				X	D350-567-031	INTERIOR FLOOR WINDOW KIT (SLIDING DOOR COMPATABLE)
1					D2125	REPLACEMENT WINDOW, SMALL
	1				D2942	REPLACEMENT WINDOW, LARGE
		1			D3290-041	REPLACEMENT WINDOW ASSEMBLY, EXTRA LARGE
1					D2126-0600	SEAL
	1				D2463-0750	NEOPRENE SEAL
		1			D2463-0860	NEOPRENE SEAL
	9	12			2600-6	1/4 TURN FASTENER
	9	12			2600-LW	WASHER
	9	12			212-12	RECEPTACLE
	22	21			AN526C832R9	SCREW (OR AN526C832-9, OR MS51957-126)
	44	42			AN960JD8	WASHER
	22	21			MS21042L08	NUT (OR MS21042-08)
	18	24			MS20426AD3-5	RIVET
2 SQ. YD	2 SQ. YD	2 SQ. YD			N/A	9.7oz 7781 'S' GLASS UNIVERSAL WEAVE
				1	D2463-0450	NEOPRENE SEAL
				1	D3210-1	DOUBLER
				1	D3211-1	BRACKET
				1	D3212-1	FLOOR WINDOW
				1	D3213-041	DOOR ASSEMBLY
			1		D3293-1	DOUBLER
			1		D3294-1	BRACKET
			1		D3295-041	FLOOR WINDOW
			1		D3296-041	DOOR ASSEMBLY
			1		D2463-0530	NEOPRENE SEAL
			9	8	AN526C632R12	SCREW (OR AN526C632-12, OR MS51957-32)
			9	8	AN960JD6	WASHER
			9	8	MS21042L06	NUT (OR MS21042-06)
			2	40	MS20470AD4-5	RIVET
			115	90	MS20470AD4-6	RIVET
			15	20	MS20470AD4-7	RIVET